

Date: Tuesday, 15/08/2006 7:45:39 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 28109	
Estimate Number : 10773	
P.O. Number : <i>N/A</i>	Part Number : D33481
This Issue : 15/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3348 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/08/2006 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 24713	Material : <i>N/A</i>
Written By : _____	Due Date : 21/08/2006 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : Est: A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.0182 sf(s)/Unit Total: 0.3640 sf(s)
1010/1025/A21/6aA SHEET

M1010941 *NA 08 17*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

NA 08 17 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: DIMENSIONAL CHECK

NA 08 17 (20)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06-08-20 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SB 06/08/24 20

6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Form as per Dwg D3348

SB 06/08/24 20

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28109

Part Number: D33481

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.08.28 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS*

26.08.28 (20)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

26.08.28

Job Completion



26.08.28

Date: Thursday, 10/08/2006 9:56:13 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 28109	
Estimate Number : 10773	
P.O. Number :	Part Number : D33481
This Issue : 10/08/2006 S.O. No. :	Drawing Number : D3348 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 24713	Material :
Written By : <u>U</u>	Due Date : 21/08/2006 Qty: 20 Um: Each
Checked & Approved By : <u>U</u>	
Comment : Est: A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
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M1010S126A

**Comment:** PURCHASING

Issue P/O: _____

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg D3348

Possible Supplier: Industrial Laser

Material release note is required.

0182 SF

M101094

Waterjet

08 08 17 (20)

2.0	D33481F	Clevis-Flat
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 CLEVIS

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 9:56:13 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 28109

Part Number: D33481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3348

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

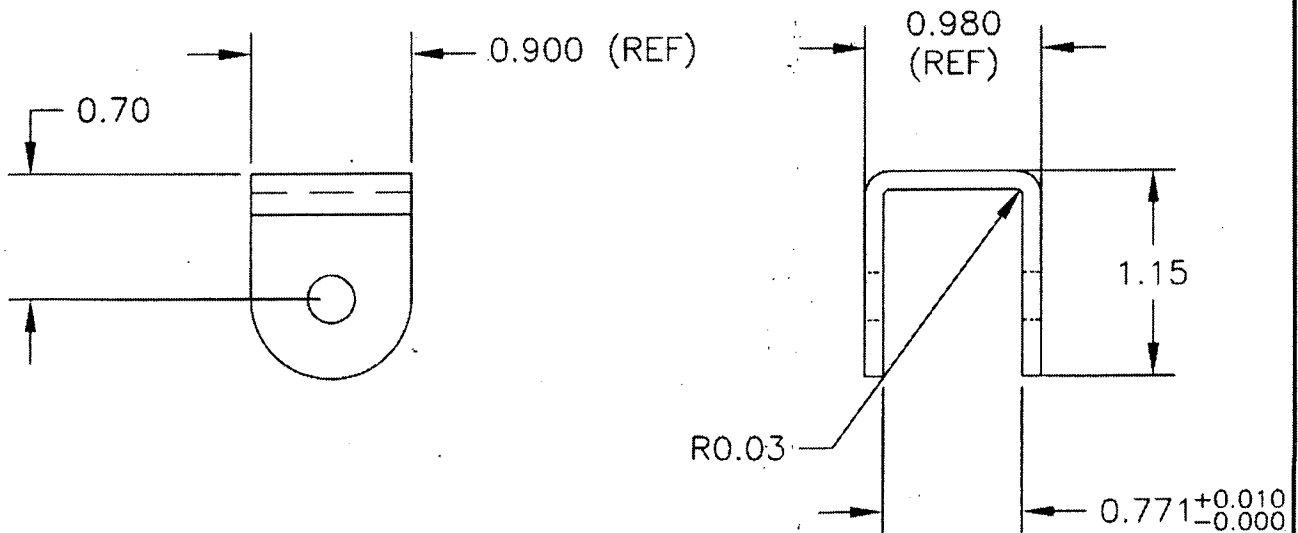
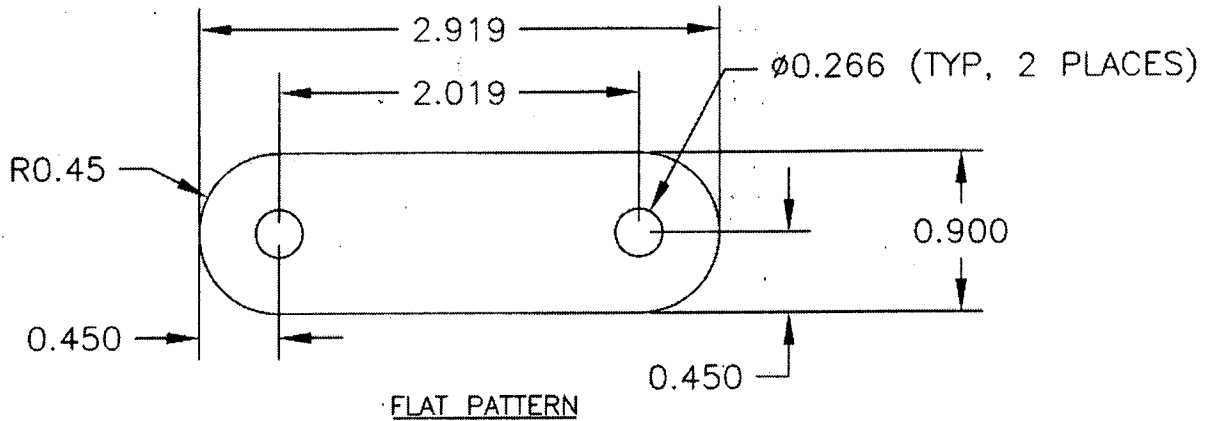
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05 03 05**D3348-1 CLEVIS**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)
(REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	28109
Description: <i>Clevis</i>		Part Number:	03348-1
Inspection Dwg:	Rev: <i>3</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST




x

First Article

X

Prototype

[illegible]

Measured by:		Audited by:		Prototype Approval:	
Date:	06/07/17	Date:	16-08-20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	